

Date: Thursday, 10/08/2006 10:02:15 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 28137		
Estimate Number	: 12507		
P.O. Number	: N/A	Part Number	: D2002007
This Issue	: 10/08/2006 S.O. No. : N/A	Drawing Number	: D2002-007 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>                    </u>	Due Date	: 05/09/2006
Checked & Approved By	: <u>                    </u>	Qty:	12 Um: Each
Comment	: Est Rev:A New Issue 06-08-10 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.1111 sf(s)/Unit Total: 0.4444 sf(s)  
 2024-T3 .063 sheet  
 (M2024T3S063)  
 Batch: M19059

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2002-007  
 Dwg Rev: B  
 Prog Rev: B

2-Deburr if necessary

M.F. 06/08/29  
 SAD 06:08:14

(10)  
 12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:08:14

12

PTD

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06/08/15 11

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1


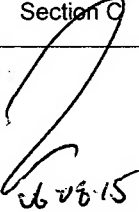

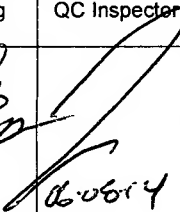
DL 06/08/29

(12)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/08/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/14	20	Node was not made properly by the waterjet one of the hole had a chip <del>at</del> in it		Scrap and destroy	JAH 06/08/14	 06/08/15		 06/08/14

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:02:15 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 28137

Part Number: D2002007

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PD 4/8/30* (12)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *STO/D*

*DB 06/08/30* (12)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*D 06/08/31* (12)

Job Completion



*CLOG 108/30*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

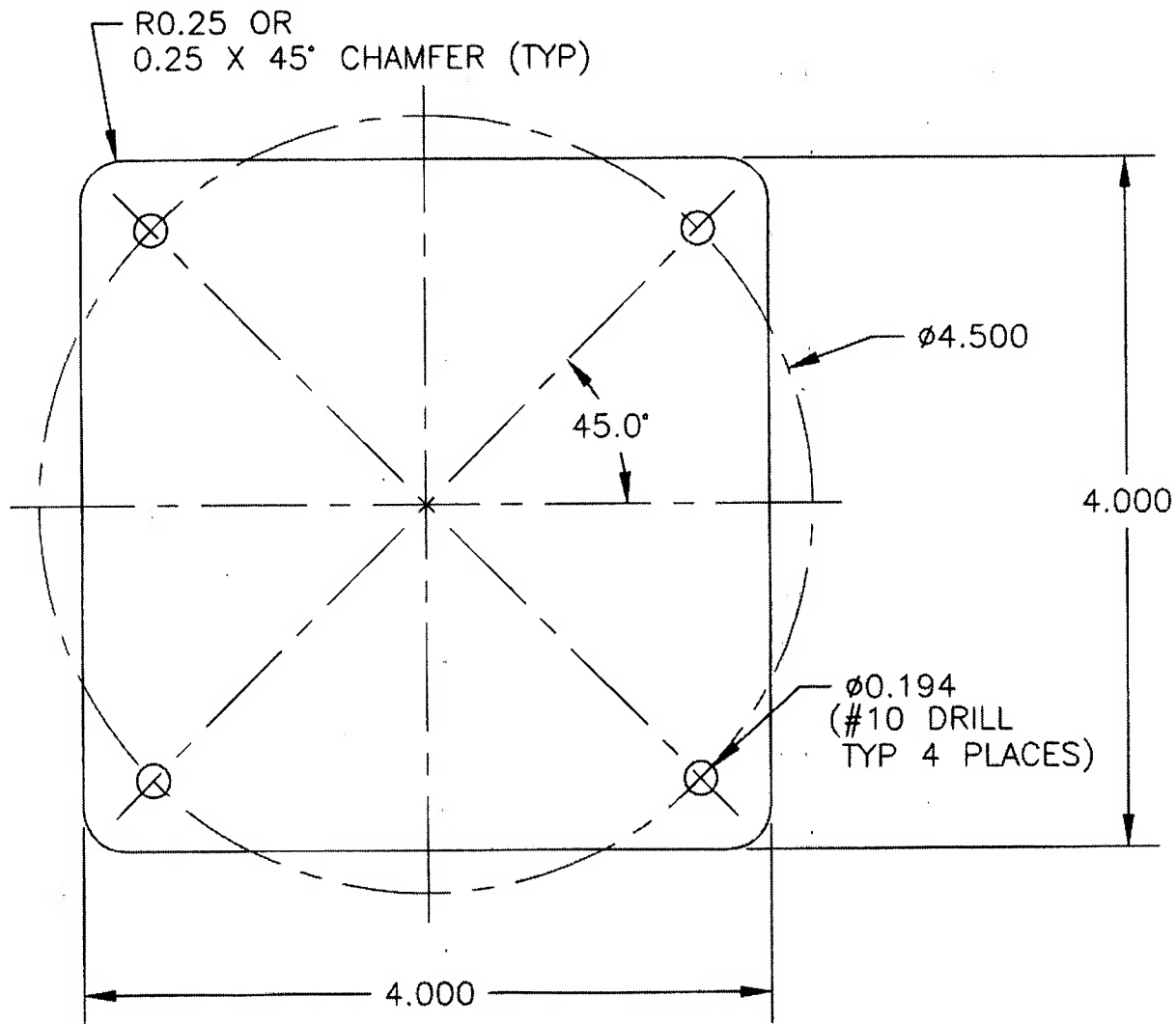
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN JB	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AT</i>	DRAWING NO. D2002-007	REV. B SHEET 1 OF 1
DATE 98.11.03		TITLE PLATE	SCALE 1:1
A	90.02.27	NEW ISSUE	
B	98.11.03	REDRAWN ON SEPARATE SHEET ADDED R0.25 OPTION, CHANGED FINISH	

RELEASED  
98.11.10 KE



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT BLACK CRINKLE (REF 4.3.5.3) PER DART QSI 005 4.3  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



